

NOTICE

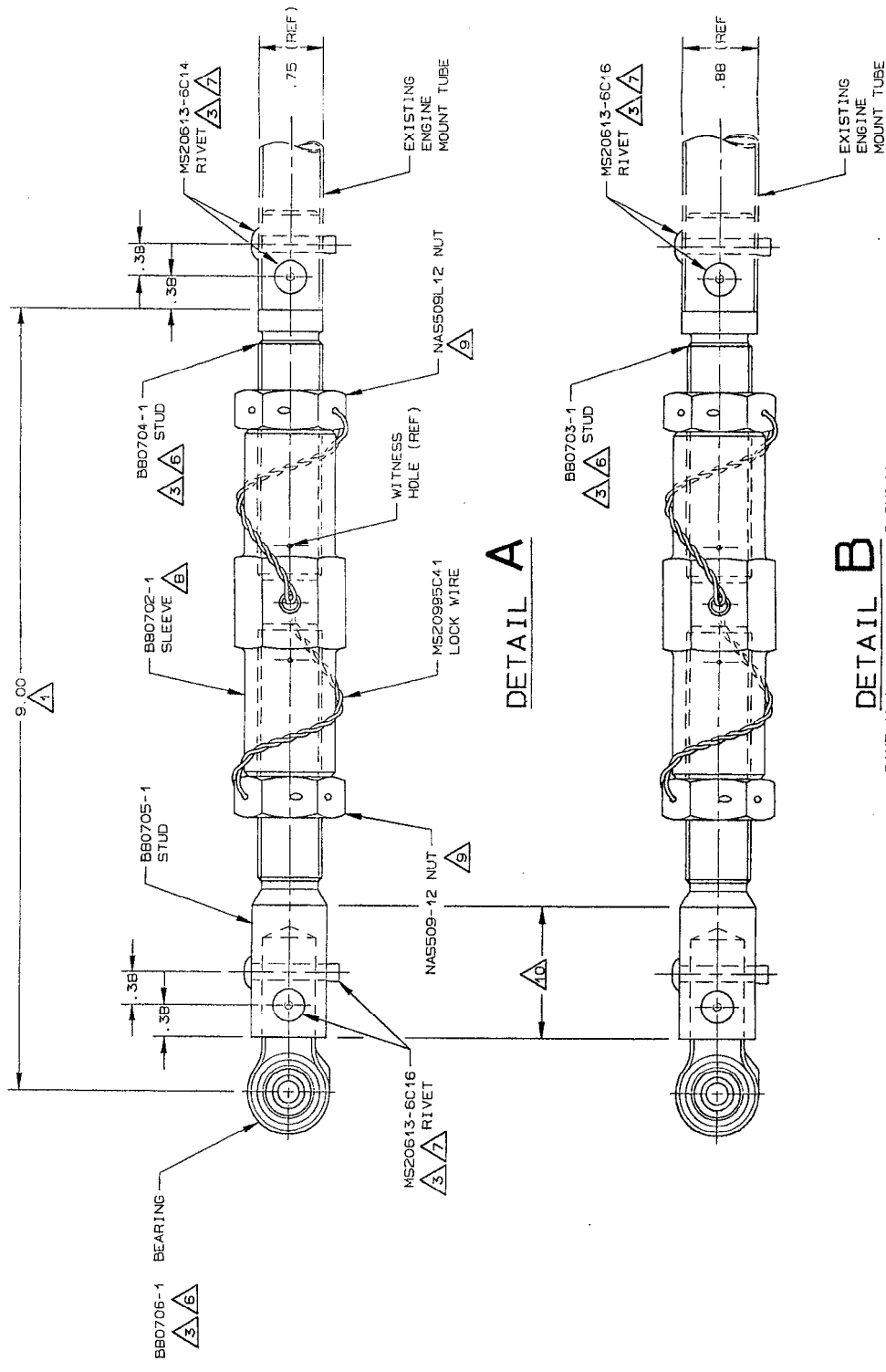
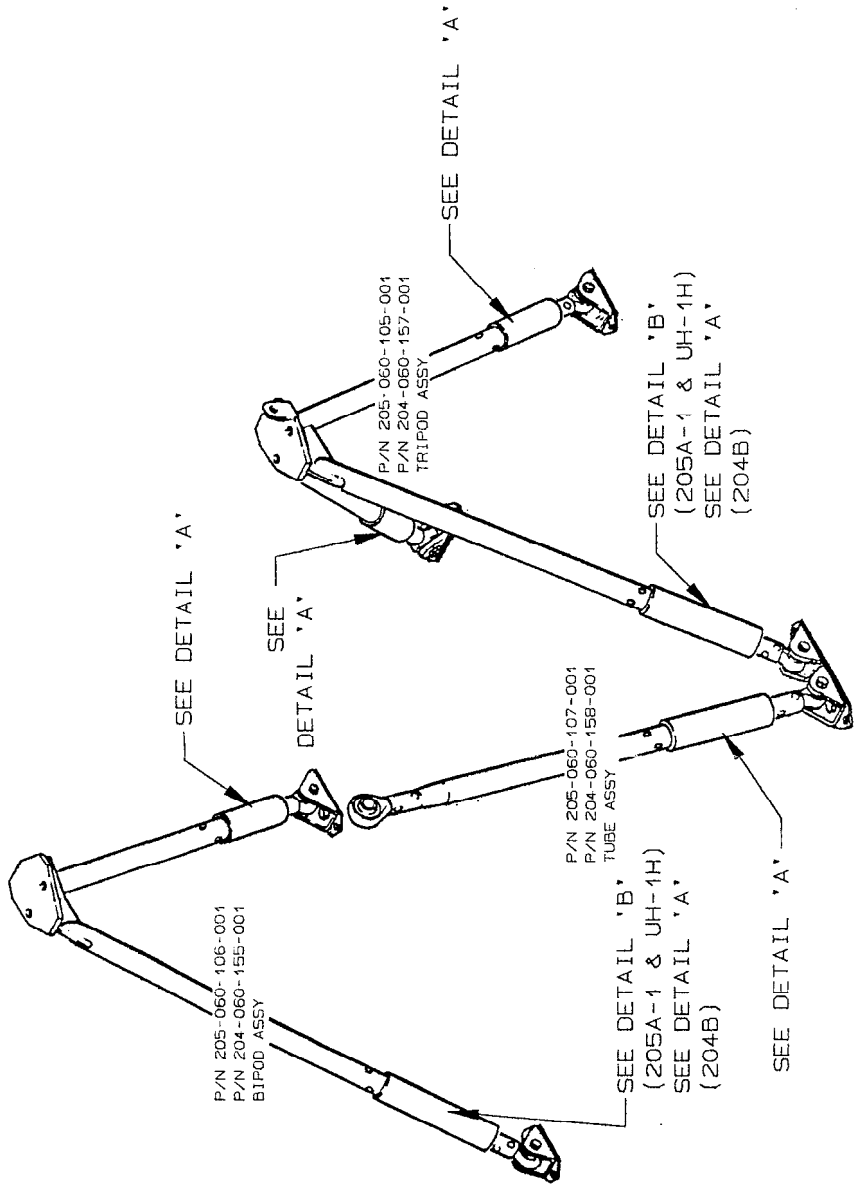
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NOTES:

1. CUT EXISTING ENGINE MOUNT TUBE AT DIMENSION SHOWN.
2. DEBURR OUTSIDE DIAMETER OF TUBE .005/-.010 AND CHAMFER INSIDE DIAMETER .045/-.025.
3. BOTTOM OUT BEARING IN BB0705 STUD AND BB0703/BB0704 STUD IN TUBE. POSITION RIVET HOLES AS SHOWN AND LINE DRILL PARTS .194 DIA (#10 DRILL).
4. DISASSEMBLE PARTS AND DEBURR.
5. ZINC CHROMATE PRIME TUBE ASSY ALL OVER USING TT-P-1757, COLOUR GREEN.
6. RE-ASSEMBLE PARTS WET WITH HYSOL ADHESIVE EA934.
7. INSTALL RIVETS WET WITH HYSOL ADHESIVE EA934.
8. FILL SLEEVE WITH CORROSION PREVENTIVE COMPOUND MIL-C-16173 SUFFICIENT TO CAUSE SQUEEZE OUT, THEN ASSEMBLE THREADED PARTS AS SHOWN.
9. FOR AIRCRAFT INSTALLATION, BACK OFF NUTS AND ORIENT BEARING TO SUIT ENGINE DECK FITTINGS. ADJUST LENGTHS OF INDIVIDUAL TUBES WITH SLEEVE TO OBTAIN CORRECT ENGINE/TRANSMISSION ALIGNMENT PER BELL MAINTENANCE MANUAL. MAKE SURE STUDS ARE STILL VISIBLE THROUGH WITNESS HOLES. TORQUE NUTS 400 TO 600 IN-LES AND LOCKWIRE AS SHOWN. SEAL LOCKWIRE HOLES IN SLEEVE AND AROUND NUT/THREAD INTERFACE WITH SEALANT PER MIL-S-8602.
10. ZINC CHROMATE WHERE INDICATED USING TT-P-1757, COLOUR GREEN.



DETAIL **B**
SAME AS DETAIL A EXCEPT AS SHOWN

QUANTITY PER		PART NO.		DESCRIPTION		MATERIAL	
UNLESS OTHERWISE SPECIFIED		APPROVALS		DATE		LIST OF MATERIALS	
dimensions are in inches		DRAWN:		27 JAN 98		NORTHERN AERO INDUSTRIES	
Tolerances on:		CHECKED:				1945 ST. MATTHEWS AVENUE	
Angles		PROJECT ENGINEER				WINNIPEG, MANITOBA R3H 0A8	
.xxx ± .010		STRESS:				INSTALLATION - ENGINE MOUNT,	
.xx ± .05						ADJUSTABLE, BELL 204/205	
.x ± .1						REV.	
AR	AR	EA934	ADHESIVE				DEXTER/HYSOL
6	6	B80706-1	BEARING				ACS
AR	AR		SEALANT				MIL-S-8802, CLASS B
AR	AR		CORROSION PREVENTIVE COMPOUND				MIL-C-16173, GRADE 1
AR	AR	MS20995C41	LOCK WIRE				
12	8	MS20613-6C14	RIVET				
12	16	MS20613-6C16	RIVET				
6	6	NAS509L12	NUT				
6	6	NAS509-12	NUT				
6	6	B80705-1	STUD				
6	4	B80704-1	STUD				
	2	B80703-1	STUD				
6	6	B80702-1	SLEEVE				
\	\	-3	INSTALLATION				
\	\	-1	INSTALLATION				

SCALE: FULL

SHEET 1 OF 1

CODE IDENT NO. **36929**

DWG. NO. **B80701**

REV. **C**

AERO CONSULTING SERVICES COMPUTER DRAFTING SYSTEM